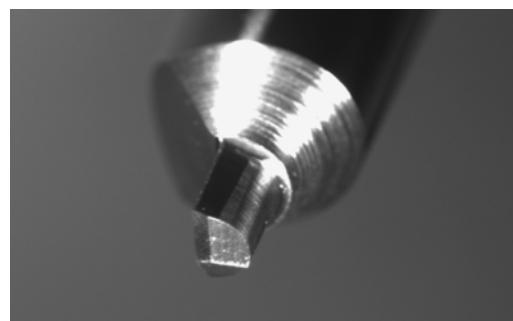
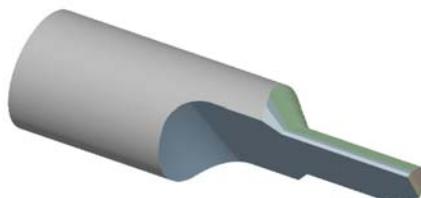


# Straight micro Endmill Ø1.1, Z1

A1-011

The cutting quality of straight micro milling cutters depends on the surface roughness of the contact surfaces. Oscillating polishing operations on cutting face, OD and end are available.



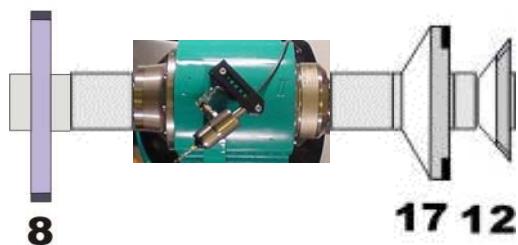
## 1. Cycletime for Production

Tool specifications Ø1.1, Z1, Length 7 mm Material CARBIDE									
Operations	Probe	Face rough	Face fin	Step 1	OD rad clr	OD clr 1+2	End clr 2	End clr 1	break
Feed [mm/Min]	2000	30	150	200	70	100	100	100	100
Power [kW]		4	2	1	1	1	1	1	1
Cutting feed [m/s]		22	24	24	24	24	24	24	24
Used wheels		17	12	8	17	12	12	12	17
Grinding time [s]	8	30	24	117	19	52	26	11	11
Total cycle time	4 Min 57								

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

## 2. Used Grinding Wheels

17 Ø125 12A2 D64  
12 Ø100 12V9 D16  
8 Ø125 1A1 D64



## 3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG  
Control: Fanuc 31i  
Coolant: Synthetic Oil, pressure 6 - 7 bar  
Software: Quinto 5

responsible engineer: OP,11.9.07

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